

Date: Thursday, 21/05/2009 3:14:55 PM
 User: Julie Dawson

Process Sheet

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	SPACER
Job Number	48103		Part Number	D30661
Estimate Number	10383		Drawing Number	D3066 REV.B
P.O. Number			Project Number	N/A
This Issue	21/05/2009	S.O. No. :	Drawing Revision	B
Prsht Rev.	NC		Material	
First Issue	/ /	Type : SMALL /MED FAB	Due Date	28/05/2009
Previous Run	47185		Qty:	40
Written By	:		Um:	Each
Checked & Approved By	JUL09-05-21			
Comment	Est:C 02.11.01 Incorporated D3066-1 IPP KJ/RF Est Rev:D Now M6061-T6 06-06-23 JLM			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S080	6061-T6 .080 Sheet
		Comment: Qty.: 0.0992 sf(s)/Unit Total : 3.9690 sf(s) Material: 6061-T6 0.080" thick (M6061T6S.080) Batch: <u>110630</u> <u>B 9-5-21</u>
2.0	WATER JET	FLOW WATER JET
		Comment: FLOW WATER JET 1-Cut as per Dwg D3066 Dwg Rev: <u>B</u> <u>B 9-5-21</u> Prog Rev: <u>B</u>
		2-Deburr if necessary <u>B 9-5-21</u>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		<u>B 9-5-21</u>
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
		<u>S 02/05/22</u> <u>cont'd</u>
		Comment: SECOND CHECK
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
		Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1
		<u>05-15-22</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 21/05/2009 3:14:55 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 48103

Part Number: D30661

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



50



JK 09-05-22

Comment: INSPECT CHEMICAL CONVERSION COAT

7.0 PACKAGING 1

PACKAGING RESOURCE #1



50

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

9/5/22

SD

8.0 QC21

FINAL INSPECTION/W/O RELEASE



09/05/26-10

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF

09-05-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	48103
Description: Spacer	Part Number:	D3066-1
Inspection Dwg: D3066	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>FB</u>	Audited by: <u>S</u>	Prototype Approval:	N/A
Date: <u>9-5-21</u>	Date: <u>09/05/22</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D3065-041	KJ/RF	
B	06.06.23	Dwg Rev. changed	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

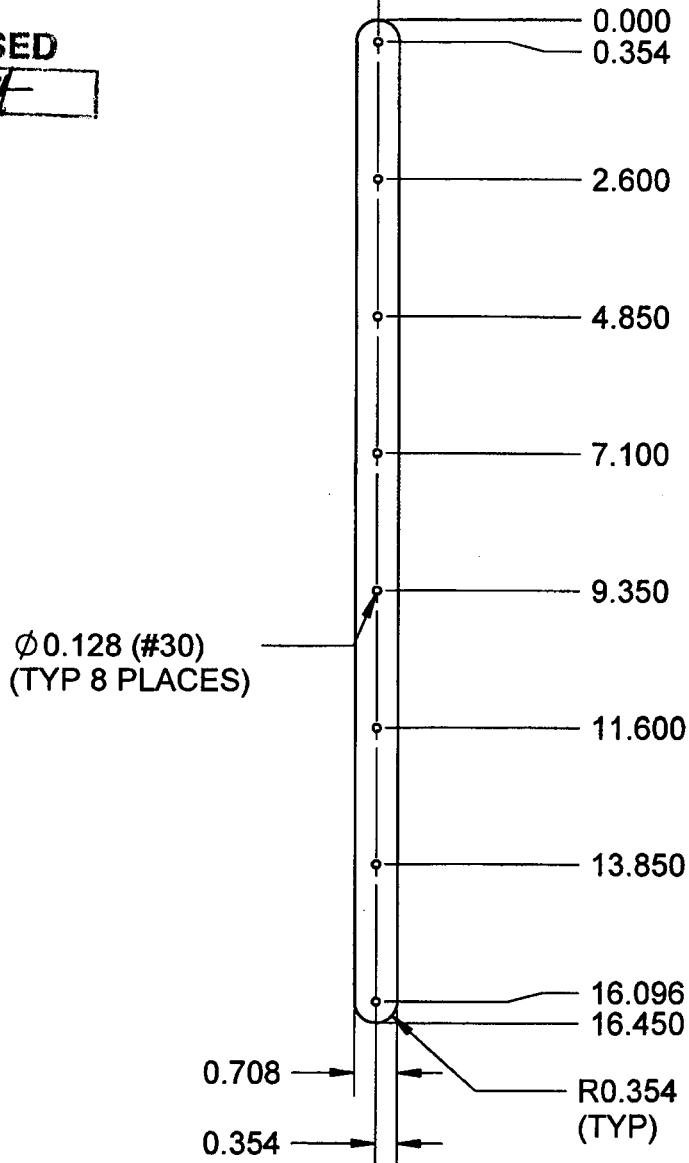
DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. REV. B D3066
DATE	06.05.29	TITLE SPACER SCALE 1:3

A	02.09.11	NEW ISSUE
B	06.05.29	ADD 6061-T6 MATERIAL

RELEASED

d.6.20 -f-



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 18103

D3066-1 SPACER

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK
(REF DART SPEC M6061T6S.080)
OR
5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK
(REF DART SPEC. M5052H32S.080)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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